

WORK INSTRUCTION

Title: **ICV/OCV Upper Main O-Ring Seal Groove Depth Measurement and Surface Finish Inspection**

Instruction No. CH.11

Rev. 0, January 2002

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Approved for Use by: Michael R. Brown Effective Date: January 2002

Applicable Drawings:

- 2077-500SNP (Sheet 7) - TRUPACT-II Packaging SARP Drawings
- 707-SAR (Sheet 6) - HalfPACT Packaging SARP Drawings

SARP Requirements:

- Chapter 8.0. Prior to first use and annually thereafter.

Tools Required:

- Surface Finish Comparator Plate
- Depth Micrometer or equivalent
- Surftest 211 (finish tester) or equivalent

Spare Parts Required:

- None

Materials Required:

- Denatured Alcohol or equivalent
- Lint-Free Rags

Safety Requirements:

- Safety will be observed in accordance with site requirements.

Prerequisite Conditions:

- Lids are removed and placed on stands.

Instruction Steps:

- Record all data from this instruction on the attached data sheets (Attachment 2, Work Instruction CH.11, Forms 1, 2, and 3).
- This instruction **is not required to be attached** to the Maintenance Record but may be used as a checklist during performance of maintenance.

1.0 If not already done, remove the ICV/OCV upper and lower main O-rings.

NOTE: If O-rings are being changed per annual requirement, discard. If not, clean thoroughly and place in plastic bag. Label the bag with "Upper Main, Lower Main O-rings For Unit No. _____."

2.0 Using alcohol and lint-free rags, thoroughly clean the grooves.

3.0 At nine equally spaced locations in the ICV/OCV upper O-ring grooves, insert the depth micrometer with the long side of the base up (see Attachment 1, Figure A). Maintaining the base flush, take reading and record it on Attachment 2, Form 1.

4.0 If the reading at any location is not between 0.247 inch and 0.253 inch, notify the CH Packaging Maintenance Engineer.

5.0 Using the Comparator Plate or Surftest 211 instrument, (See Attachment 1, Figure B) check surface finish of the bottom of both upper and lower O-ring grooves at 9 equally spaced locations and record readings on Attachment 2, Form 2.

6.0 Using the Comparator Plate or Surftest 211 instrument, (See Attachment 1, Figure B) check surface finish of the upper seal flange sealing area of ICV and OCV lids at nine equally spaced locations and record readings on Attachment 2, Form 3.

7.0 If not replacing main O-rings as part of annual maintenance, clean and reinstall main O-rings previously placed in plastic bags in accordance with Work Instruction CH.02.

NOTE: If surface finish at any location in either Step #5 or #6 exceed 125 micro inches, go to Work Instruction CH.12 for repair. Perform simultaneous groove depth measurements to ensure maximum dimension (depth) is not exceeded.

Verification Requirements:

1.0 Work performed is described on Maintenance Record.

2.0 Work instruction is listed on Maintenance Record.

3.0 Data sheets (Work Instruction CH.11, Forms 1, 2, and 3) are attached to Maintenance Record.

ATTACHMENT 1

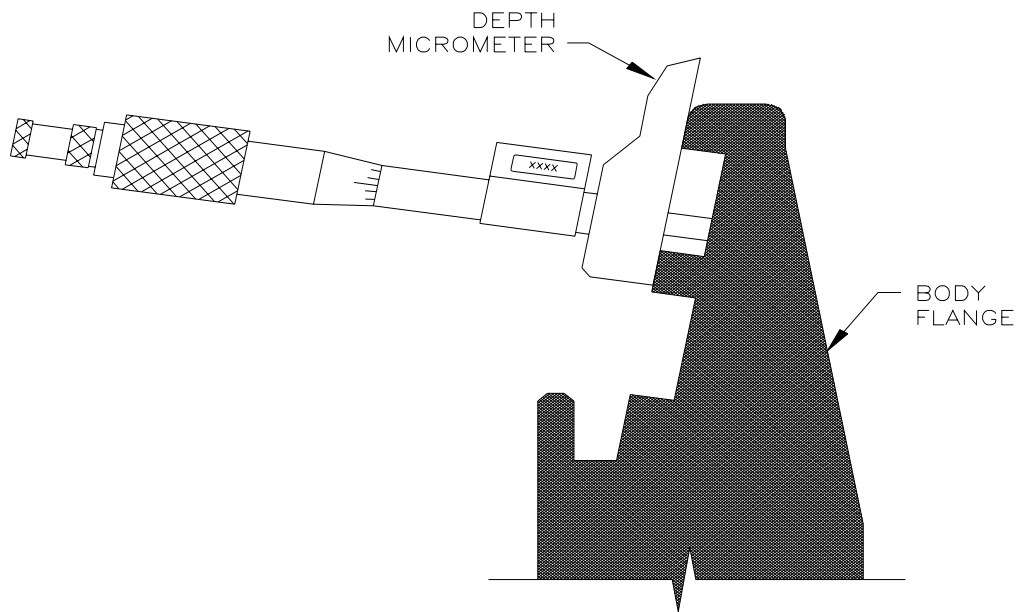


FIGURE A

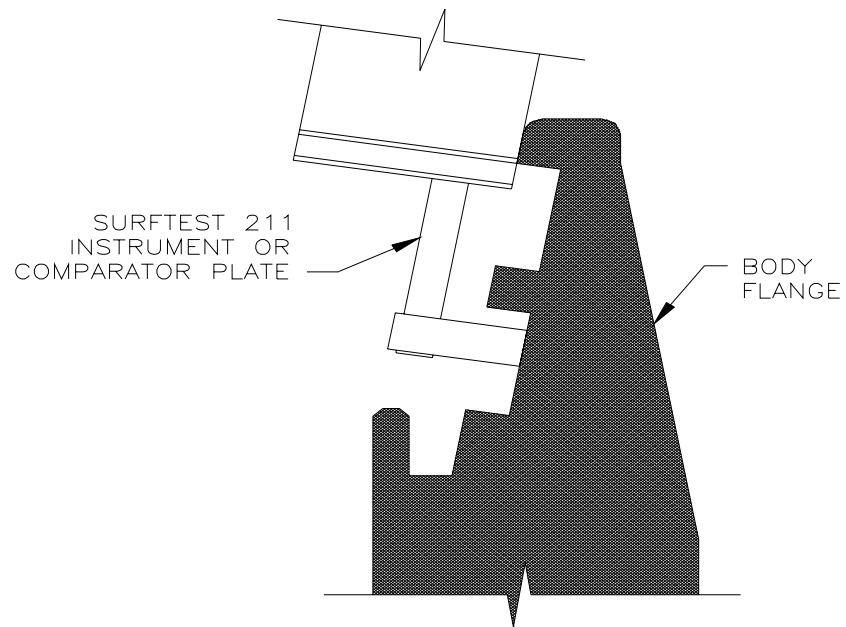
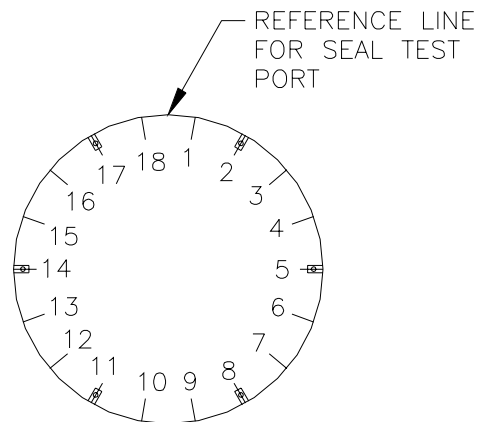
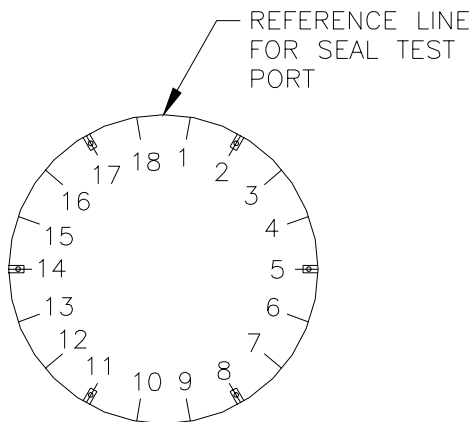


FIGURE B

Attachment 2, Form 1 - ICV/OCV Upper Main O-ring Seal Groove Depth Measurement
 Packaging S/N: _____ Date: _____ Job No.: _____



ICV	
Loc.	Depth (in.)*
2.	
4.	
6.	
8.	
10.	
12.	
14.	
16.	
18.	

OCV	
Loc.	Depth (in.)*
2.	
4.	
6.	
8.	
10.	
12.	
14.	
16.	
18.	

* Groove depth is 0.250 ± 0.003 in. (0.247 to 0.253)

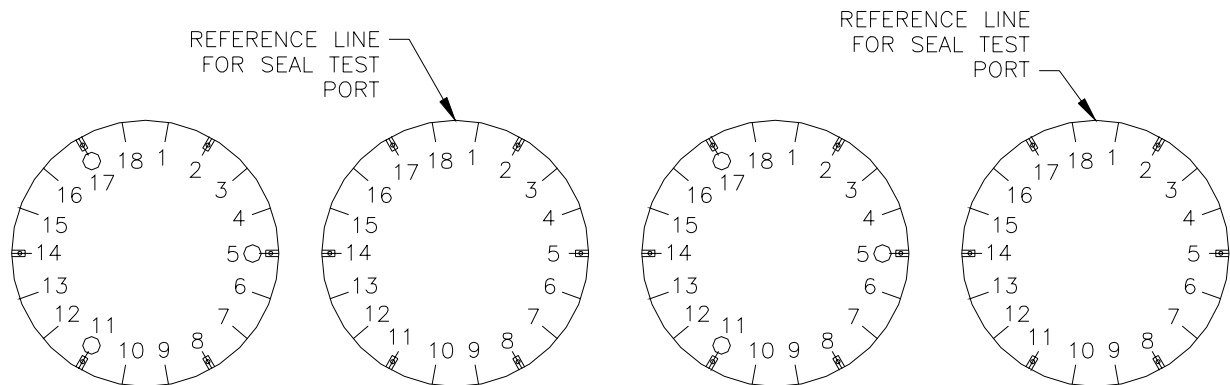
* If any location is out of tolerance, notify the CHME

Depth Micrometer S/N: _____ Calibration Due Date: _____

QA: _____ Date: _____

Attachment 2, Form 2 - ICV/OCV Upper/Lower O-ring Groove Surface Finish

Packaging S/N: _____ Date: _____ Job No.: _____



ICV			OCV		
Loc.	Upper Finish	Lower Finish	Loc.	Upper Finish	Lower Finish
2.			2.		
4.			4.		
6.			6.		
8.			8.		
10.			10.		
12.			12.		
14.			14.		
16.			16.		
18.			18.		

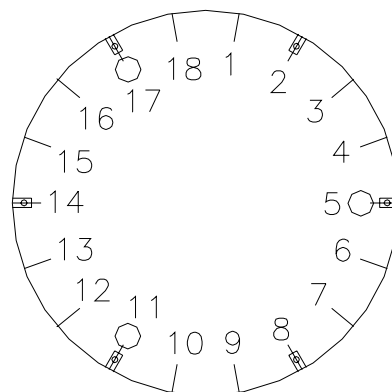
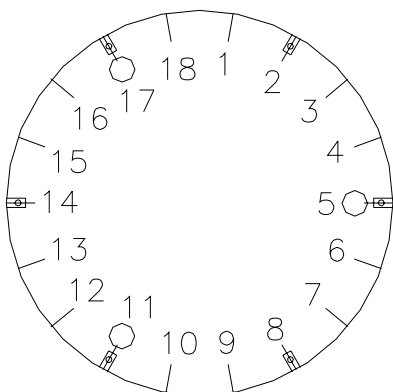
* If the Surface finish is greater than 125 micro inches at any location, go to Work Instruction CH.12 for repair.

Comparator or Surftest 211 S/N: _____ Calibration Due Date: _____

QA: _____ Date: _____

Attachment 2, Form 3 - ICV/OCV Upper Seal Flange Seal Area Surface Finish

Packaging S/N: _____ Date: _____ Job No.: _____



ICV Upper Seal Flange		OCV Upper Seal Flange	
Loc.	Finish	Loc.	Finish
2.		2.	
4.		4.	
6.		6.	
8.		8.	
10.		10.	
12.		12.	
14.		14.	
16.		16.	
18.		18.	

* If the Surface finish is greater than 125 micro inches at any location, go to Work Instruction CH.12 for repair.

Comparator or Surftest 211 S/N: _____ Calibration Due Date: _____

QA: _____ Date: _____